

Claims

1. Method for forming glossy and matt surface zones (22, 24) when printing a can body (18) in a production line (10) comprising:

- 5 - a priming varnishing machine (12) for applying a priming layer (26) to the can body,
 - a printing machine (14) for applying printing colours (30) including at least one glossy colour (28) to the can body (18) provided with the priming layer,
 - 10 - and a finish varnishing machine (16) for applying a finish varnish (32) to the can body (18) provided with the priming layer and printed,
- method characterized in that a matt varnish is applied as finish varnish (32), after drying of the inks, by means of a flexographic printing plate controlled by dot-for-dot marking or by means of a cylinder (44) controlled by dot-for-dot
- 15 marking, to the zones of the can body (18) designed to give a matt surface (24).

2. Method according to claim 1, characterized in that the zones that are to form a glossy surface (22) are printed with a glossy printing colour (28).

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3. Method according to claim 1, characterized in that the glossy surface zones (22) are formed by a glossy can surface (20).

4. Method according to claim 3, characterized in that the can surface (20) is rendered glossy by brush smoothing.

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5. Method according to any one of the claims 1 to 4, characterized in that the can body (18) is manufactured from aluminium or from an aluminium alloy or from tinplate.

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6. Method according to any one of the claims 1 to 5, characterized in that the priming varnishing machine (12) and the finish varnishing machine (16) are equipped with a flexographic printing unit and with an inking distributing mechanism (34).

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7. Application of the method according to any one of the claims 1 to 6 to form a "Spot-Varnish" effect on the surface of the can body (20).